

Work Order ID 62121

Thursday, September 16, 2010 9:55:53 AM



Page 1

Item ID: PB67-43001-291

Accept



Setup Start



Revision ID:

Item Name: Clamp Bushing

Stop



Start Date: 9/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	<i>MR</i>	Date: 10-9-16	Tooling:	Date:	Run	Start		
	QC:		Date:	SPC (Y/N):	Date:		Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
B67-43001	C	

100 4 6

 Hardinge CNC LATHE SMALL

Hardinge 4 6
 Hardinge CNC Lathe Small 4 6
 Memo Turn as per Folio FA 557 & Dwg B67-43001

ST 10/09/26

110 4 6

 QC2- Inspect parts off machine FAI/FAIB 4 6
 Memo

ST 10/09/26

120 4 6

 CONVENTIONAL MILLING MACHINE 4 6

Mill Conv 4 6
 Conventional Milling Machine 4 6
 Memo Mill slot as per Dwg B67-43001

ST 10/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/09/26

4 ♂

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 10/09/27

4 ♂

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BK 10-9-27

4 ♂

W/O:		WORK ORDER CHANGES					
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Start Date: 9/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

20109121

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

4

9

170



Packaging

Packaging

Identify as per dwg & Stock Location: 438A

0.00

0.00

Croft/SB 4

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/2010

CL 10/9/2010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 62121



Parent Item: PB67-43001-291



Parent Item Name: Clamp Bushing

Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.08.26 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.500		Purchased		No		100	f	16.4000	0.1023	0.430737			

6061-T6 Round Bar 1.50



Location	Loc Qty	Loc Code
MAT013	16.4	
110167	16.4	

43 sh w/ 9/26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62121
Description:	Part Number:	PR36743ee1 - 291
Inspection Dwg:	Rev:	C
		Page 1 of 1

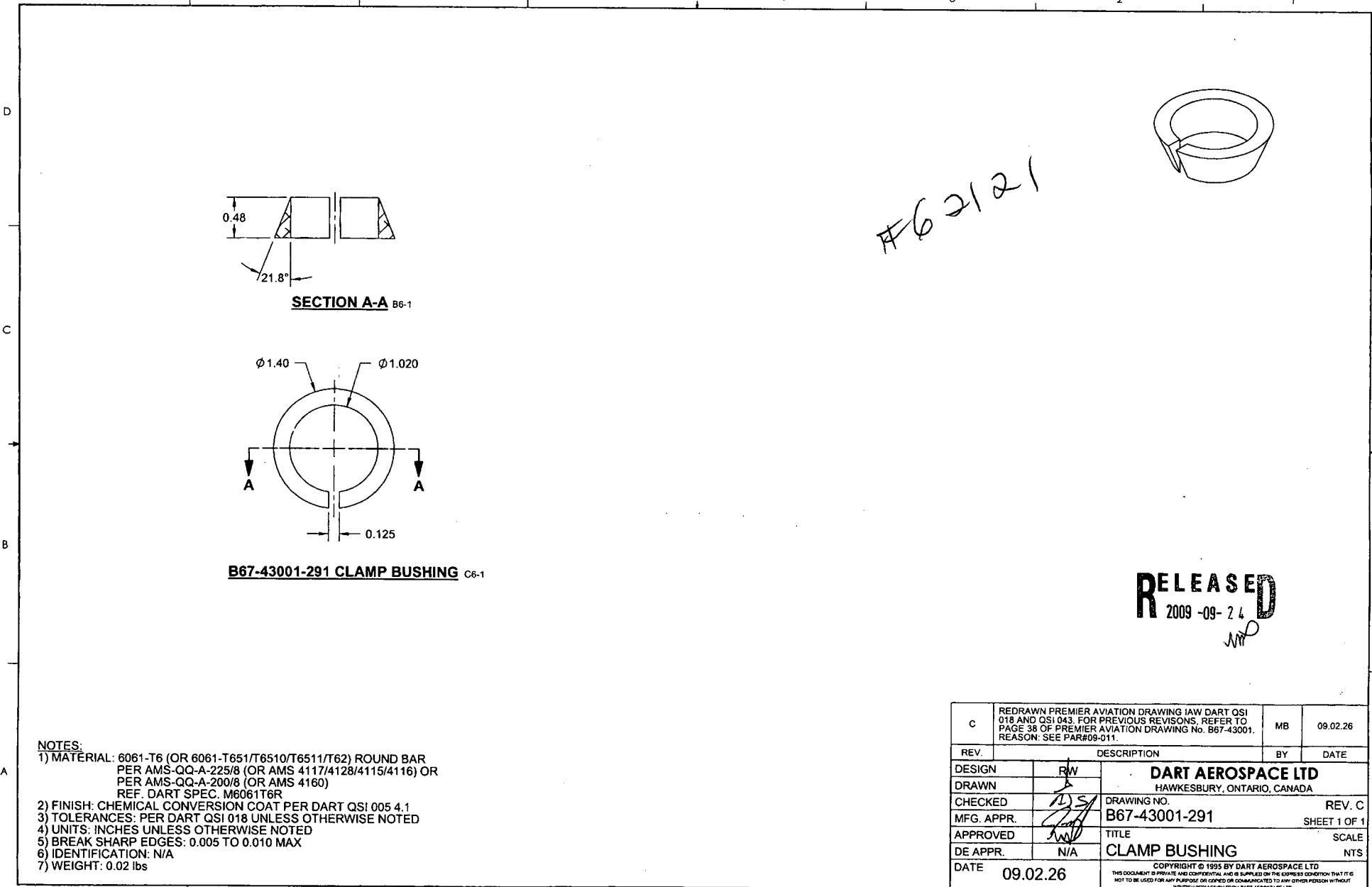
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	S.A	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/09/26	Date:	10/09/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 38 OF PREMIER AVIATION DRAWING NO. B67-43001. REASON: SEE PAR#09-011.			MB	09.02.26
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			A
DRAWN		DRAWING NO.	B67-43001-291	REV. C	
CHECKED	TJS	MFG. APPR.		SHEET 1 OF 1	
APPROVED	SW	DE APPR.	N/A	TITLE	SCALE
				CLAMP BUSHING	NTS
		DATE	09.02.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

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